



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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DSK078

Job Sheet 192667



Part No: DSK078

Job Qty: 10 pcs

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/29/19

Job Tracking No:

Due Date: 4/17/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	4/17/19	4/17/19	0.50	8.77	Doosan - 1		<i>Marie Lajeunesse April 5/19</i>
110	QC 2	10 pcs	4/17/19	4/17/19	0.00	0.00	QC 2 - 1		<i>Marie Lajeunesse April 8/19</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S170125



Part: DSK078

Job No: 192667

Serial No/Batch: S170125

Revision:

Inspector:

Exp Date:

Instructions:

Date: 04/05/19

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120 QC 8	10 pcs	4/17/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm 12/01/08
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Packaging 3-1 - Stock - B4B	10 pcs	4/17/19	0.00 0.00	Packaging 3 - 1 - B4B	mm 12/01/08
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	4/17/19	0.00 0.00	QC 21 - SA - 21	APR 08 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Doosan (Doosan Lathe) Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492) Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: <u>mm</u>) LOCATION: <u>MAT060</u> 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6104-005	Round Billet, 17-4	10 pcs (1 ea)	100-Doosan - 1	S127126	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6104-005	10	38	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	192667
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	X	2.705	2.710	2.710	2.710	2.710
B	4.946	4.966		4.954	4.950	4.948	4.950	4.951
C	3.064	3.084		3.074	3.074	3.075	3.074	3.073
D	0.718	0.738		.725	.726	.728	.725	.730
E	0.090	0.110		.094	.092	.092	.094	.099
F	2.934	2.954		2.943	2.945	2.946	2.945	2.943
G	2.166	2.186		2.175	2.174	2.175	2.175	2.173
H	3.890	3.910		3.900	3.900	3.901	3.901	3.901
I	0.914	0.934		.918	.918	.920	.925	.924
J	0.022	0.042	X	.032	.032	.032	.032	.032
K	0.109	0.129		.116	.116	.115	.116	.115
L								
M								
N								
O								
P								

Measured by:	Miguel Samal	Date:	19/04/06
Audited by:	mnc	Date:	17/04/08
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	192667
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	X	2.710	2.709	2.709	2.708	2.709
B	4.946	4.966		4.950	4.950	4.956	4.950	4.950
C	3.064	3.084		3.075	3.071	3.074	3.078	3.073
D	0.718	0.738		.726	.728	.728	.724	.728
E	0.090	0.110		.09	.09	.09	.09	.100
F	2.934	2.954		2.943	2.943	2.943	2.943	2.943
G	2.166	2.186		2.175	2.175	2.176	2.175	2.175
H	3.890	3.910		3.901	3.901	3.900	3.903	3.901
I	0.914	0.934		.926	.922	.923	.928	.927
J	0.022	0.042	X	.032	.032	.032	.032	.032
K	0.109	0.129		.114	.114	.115	.117	.114
L								
M								
N								
O								
P								

Measured by:	Miguel Sanel	Date:	April 5 th 2009
Audited by:	mmc	Date:	12/04/08
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					